

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027293**Date Inspected:** 08-Mar-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Westmont Industries**Location:** Santa Fe Springs. Ca

<b>CWI Name:</b>	Chris Concha		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A

**Bridge No:** 34-0006**Component:** SAS Travelers**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the Westmont Industries (WMI) job site in Santa Fe Springs, California between the times noted above in order to monitor fabrication and the Quality Control functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path). The following items were observed:

Modified Brake Mounts Traveler Trolley Train Links (CCO232)

This QA Inspector randomly observed WMI production welder Mr. Jose Lopez performing welding activities on material ASTM A572 Grade 50 angle 8" x 8" x 7/8" x 1-3-1/4" angle material joining angle plates to link suspension plates 2A, 2B, 3A, & 3B. Mr. Lopez was observed welding using approved Flux Cored Arc Welding with Gas (FCAW-G) process, welding fillet and groove welds in all positions. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Chris Concha was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welder was currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Concha verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the

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applicable WPS.

### Maintenance Travelers

This QA Inspector performed random shop observations and observed that Zemarc Corporation is on site at WMI today. Zemarc personnel informed this QA Inspector that Zemarc will continue installing various sizes of compressed air lines and console frames on the SAS-EB, E2/E3-EB, E2/E3 WB Maintenance Travelers today.

### RPI Coating (Zinc coat testing)

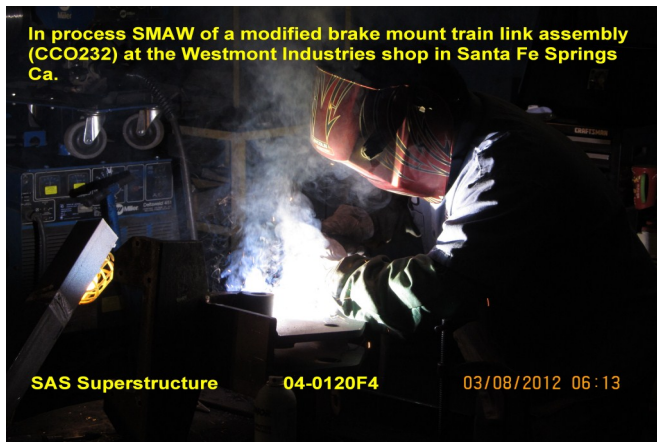
This QA Inspector observed that RPI is on site to perform various testing on Modified Brake Mounts Traveler Trolley Train Links (CCO232) after the elapsed seventy-two (72) hour cure time. This QA Inspector observed the pencil test, quarter test and recorded the adhesion test readings of 940 and 1,100. Upon completion of the testing the parts were water spray cleaned and set out to dry.

Mr. Bill Casey was onsite today to discuss manufacturing issues with Westmont Industries and to observe progress of the maintenance travelers.

This QA noted above items observed appear to comply with the contract documents.

### Summary of Conversations:

As noted above.



### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Frey,Doug

Quality Assurance Inspector

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**Reviewed By:**      Levell,Bill

QA Reviewer